

D3075-1

Work Order ID 116954

B116954

116954

Page 1

May-23-14 10:12:30 AM

Item ID: D3075-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw(Foot Print Only)

Start Date: 4/28/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/28/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3075

Rev B

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO

24350

CUT BLANK AS PER FILE D3075-1_BLANK

CL 14/05/26 12

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

12x 14-6-10

118

QC6- Inspect dimensions to drawing

0.00

118

QC

Memo

0.00

Quality Control

CL 14/06/17

12

May-23-14 10:12:30 AM

Page 2

0.00

Work Order ID 116954***116954***

Page 3

Item ID: D3075-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw(Foot Print Only)

Start Date: 4/28/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/28/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00	PP	116712.		12x		146-18	DAS 26 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00						14/6/19	JJ
Quality Control									

14618

Picklist Print

May-23-14 10:12:29 AM

Page 1

Work Order ID: 116954

116954

Parent Item: D3075-1

D3075-1

Parent Item Name: Bearpaw(Foot Print Only)

Start Date: 4/28/14

Required Date: 4/28/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM

IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM

IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	400.0000	1	12			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CD 14/05/28

Location

Loc Qty

Loc Code

MAT018

400

m128267

47

m128668

353

m129293

DART AEROSPACE LTD		Work Order:	116954
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

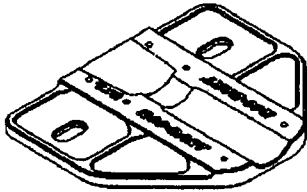
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.060	✓		MJP-04	VARN
B	0.63	+/-0.030	0.638	✓	
C	0.250	+/-0.010	0.255	✓		MJP-01	MIC
D	0.950	+0.030/-0.010	0.957	✓		MJP-04	VARN
E	5.50	+/-0.030	5.495	✓		↓	↓
F	0.25 x 45°	+/-0.030	0.250	✓			
G	0.900	+/-0.010	0.900	✓			
H	0.375	+/-0.010	0.374	✓			
I	1.30	+/-0.030	1.300	✓			
J	5.70	+/-0.030	5.700	✓			
K	0.37	+/-0.030	0.373	✓			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	0.260	✓			
N	0.93	+/-0.030	0.932	✓			
O	0.30	+0.030/-0.000	0.330	✓		6A-08	Dial depth gauge
P	1.08	+/-0.030	1.080	✓		MJP-04	VARN
Q	5.870	+/-0.010	5.87	✓	
R	10.14	+/-0.030	10.140	✓		MJP-07	Tape

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	14/06/16	Date:	14/6/16	Date:	N/A

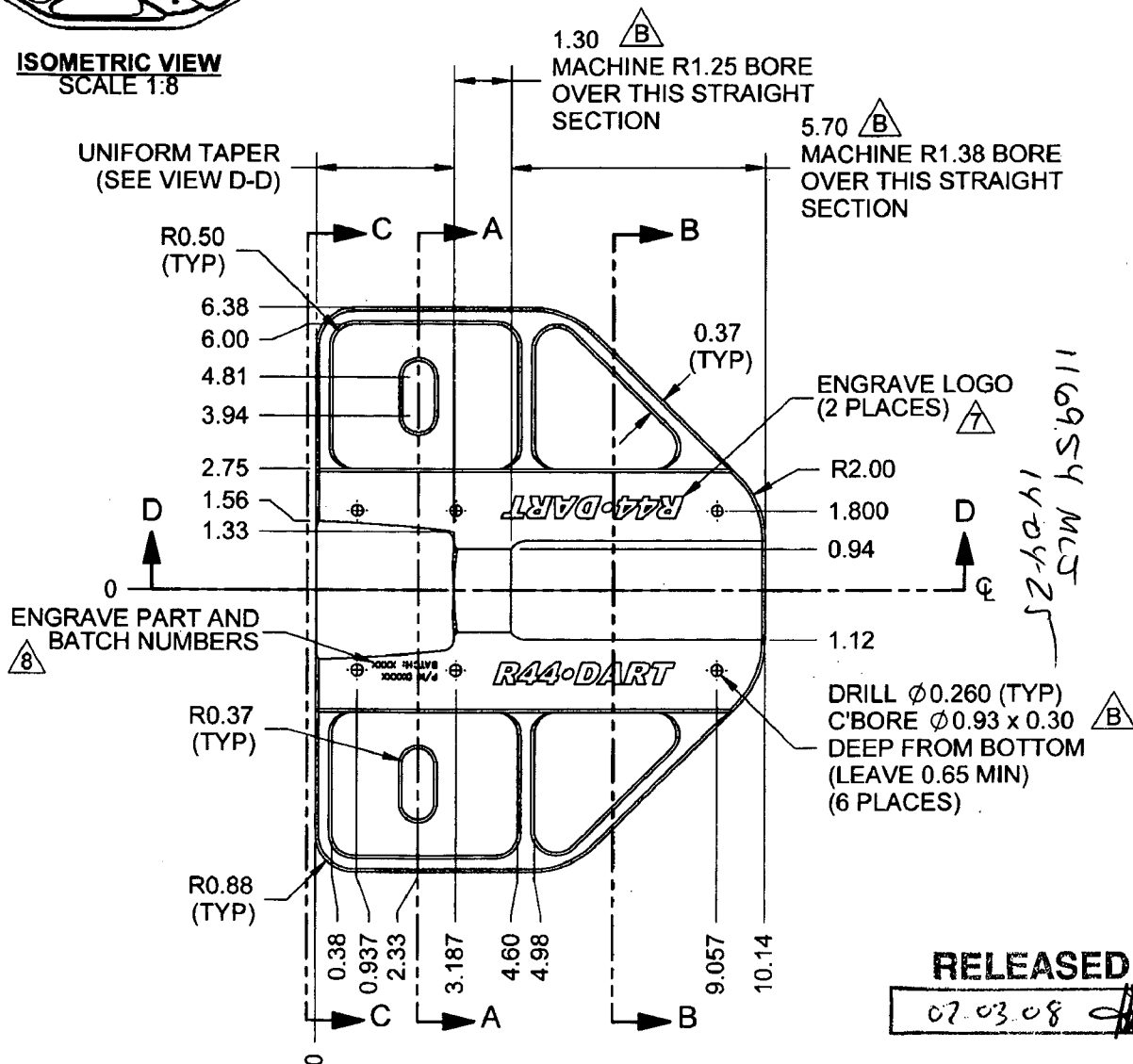
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27	TITLE R44 BEARPAW SCALE 1:4		
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8



D3075-1 BEARPAW

NOTES:

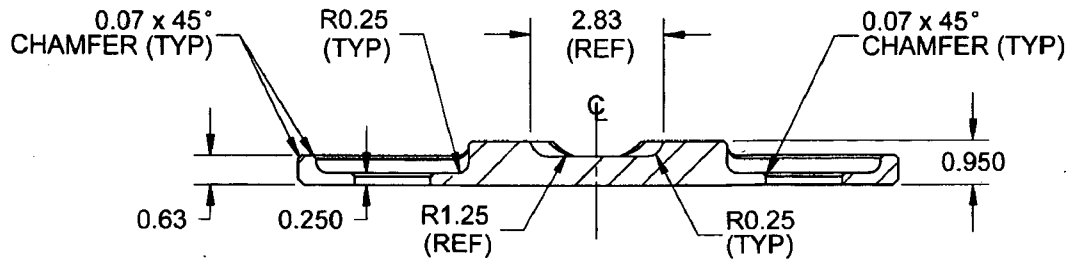
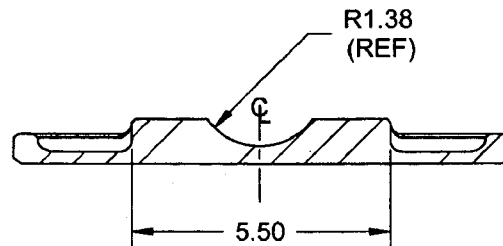
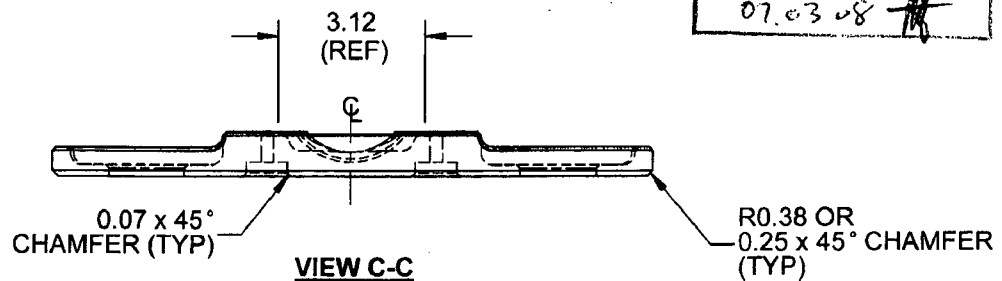
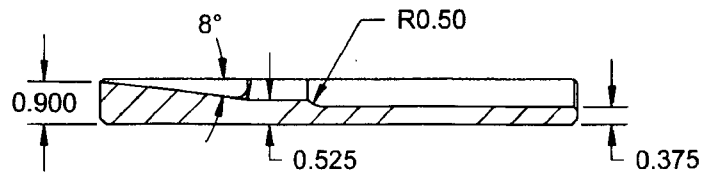
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27	TITLE R44 BEARPAW SCALE 1:4		

**SECTION A-A****SECTION B-B****VIEW C-C****SECTION D-D****RELEASED**

07.03.08

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24350

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 3 of 4

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

7	117863	D2916-3 CABLE GUARD	6/13/2014 Yes 6/13/2014	8.00	✓	\$24.80	\$198.
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CUT BLANK AS PER FILE

Line Total: ~~\$198.~~

8	117834	D3049-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$33.30	\$399.
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CUT BLANK AS PER FILE

Line Total: ~~\$399.~~

9	116954	D3075-1 BEARPAW	6/13/2014 Yes 6/13/2014	12.00	✓	\$18.37	\$220.
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CUT BLANK AS PER FILE

Line Total: ~~\$220.~~

SP14-6-10

Note:

5/26/2014